

# Work Order ID 69858

Friday, May 20, 2011 10:40:47 AM



Page 1

Item ID: D4038-7

Accept



Setup Start



Revision ID:

Item Name: Block

Stop



Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

*CL*

Date: 11/05/20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4038

DJR

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 2.3" LONG

*ont 11/06/07*

*2 0*

105

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA884

DWG REV: *E*

FOLIO REV: *AA*

DEBURR

*SL 11/06/07*

*(2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69858**

Friday, May 20, 2011 10:40:47 AM



Page 2

Item ID: D4038-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Block

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 11/06/07

2

0



QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

B.A 11/06/07

2

0



QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2x 0 M-14/06/08

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69858**

Friday, May 20, 2011 10:40:47 AM



Page 3

Item ID: D4038-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Block

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
160  Packaging Packaging	Identify as per dwg & Stock Location  Memo	0.00  0.00							
170  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

2 0 11/06/08

EP 11/06/09 (2)

11/06/09  
MF  
11-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, May 20, 2011 10:40:45 AM

Page 1

Work Order ID: 69858



Parent Item: D4038-7



Parent Item Name: Block

Start Date: 5/20/2011

Required Date: 6/10/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.00 0		Purchased	No				f	6.8057		0.349474			



6061-T6 Bar 1.50 x 2.00

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT010	6.80568	
110167	1	
→ 114608	5.80568	

.3495 on 5/21/06/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

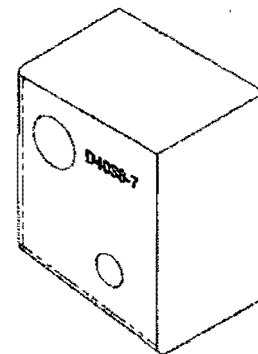
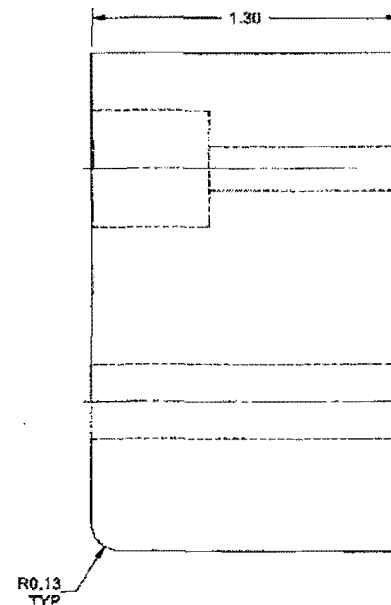
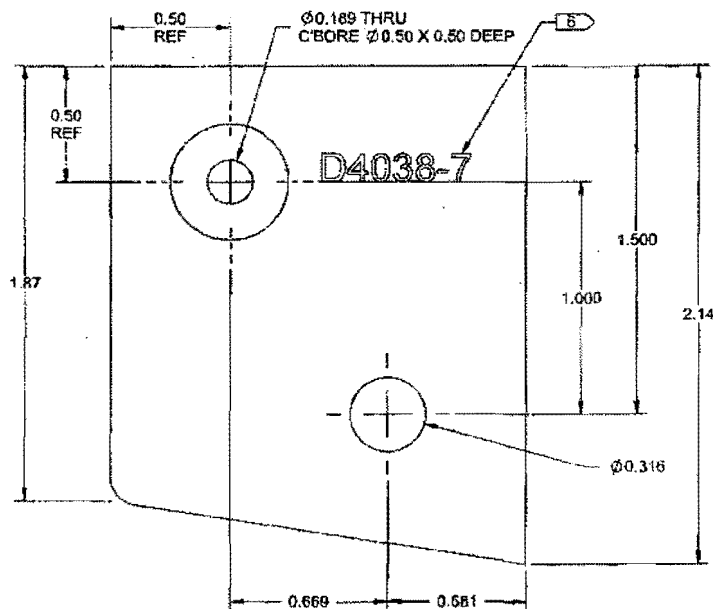
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries









**D4038-7 BLOCK**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 006 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH  
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.42 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4038	SHEET 9 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.04.11	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
ALL DOCUMENTS AND/OR DRAWINGS ARE THE PROPERTY OF DART AEROSPACE LTD AND ARE NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

**RELEASED**  
R 2011-04-21

69858

